

Date: Wednesday, 10/09/2008 3:46:37 PM
 User: Julie Lecocq

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: DUAL HIGH BACK SEAT
Job Number	: 41957		
Estimate Number	: 12271		
P.O. Number	:	Part Number	: D350689041
This Issue	: 10/09/2008 S.O. No. :	Drawing Number	: IIN-D350-689 PG9
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: / / Type : LARGE FAB ASSY	Drawing Revision	: A
Previous Run	: 37809	Material	:
Written By	:	Due Date	: 15/10/2008 Qty: 1 Um: Each
Checked & Approved By	: <u>JLO 08.9.11</u>		
Comment	: Est Rev:H Removed Sub-Parts 06-02-09 JLM Est Rev:I As per NCR 070 06-09-06 JLM		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	D30231	Back Panel
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D3023-1 Back Panel

B12445

SS 08/11/05

2.0	D3017041	Back Frame Assembly
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D3017-041 Back Assembly

37870

SS 08/11/05

3.0	MS20600AD4W2	Rivet
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Comment: Qty.: 40.0000 Each(s)/Unit Total : 40.0000 Each(s)

Pick:

Qty Part Number Description Batch

40 ms20600ad4w2 Rivet

M180513

SS 08/11/05

4.0	MS20600AD4W3	Cherry Rivets
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Comment: Qty.: 6.0000 Each(s)/Unit Total : 6.0000 Each(s)

Cherry Rivets

Batch:

M18071

SS 08/11/05

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 10/09/2008 3:46:37 PM
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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: DUAL HIGH BACK SEAT

Job Number: 41957

Part Number: D350689041

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Assemble as per IIN 350-689-041

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

7.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

8-30
320 °F
9-00

M-1 08/11/06

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

9.0

D30241

Spacer



Comment: Qty.: 3.0000 Each(s)/Unit Total: 3.0000 Each(s)

Pick:

Qty Part Number Description Batch

3 D3024-1 Spacer

33368

SS 08/11/05 (X)

10.0

D30281

Stud



Comment: Qty.: 4.0000 Each(s)/Unit Total: 4.0000 Each(s)

Pick:

Qty Part Number Description Batch

4 D3028-1 Stud

33369

SS 08/11/05 (X)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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Date: Wednesday, 10/09/2008 3:46:37 PM
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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: DUAL HIGH BACK SEAT

Job Number: 41957

Part Number: D350689041

Job Number:



Seq. #:

Machine Or Operation:

Description :

11.0

D30291

Spring



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number Description Batch

2 D3029-1 Spring 33370

*comp take Qty.
won't take Qty.*

SS 08/11/05 (X)

12.0

D30301

Lock



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number Description Batch

2 D3030-1 Lock 42517

SS 08/11/05 (X)

13.0

D30311

Loop



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number Description Batch

2 D3031-1 Loop 33474

SS 08/11/05 (X)

14.0

AN312A

Bolt



Comment: Qty.: 3.0000 Each(s)/Unit Total : 3.0000 Each(s)

Pick:

Qty Part Number Description Batch

3 AN3-12A Bolt M106605

SS 08/11/05 (X)

15.0

AN960JD10L

Washer



Comment: Qty.: 23.0000 Each(s)/Unit Total : 23.0000 Each(s)

Pick:

Qty Part Number Description Batch

23 AN960JD10L Washer M105793

SS 08/11/05 (X)

16.0

MS21042L3

Nut



Comment: Qty.: 23.0000 Each(s)/Unit Total : 23.0000 Each(s)

Pick:

Qty Part Number Description Batch

23 MS21042L3 Nut (or -3) M109031

SS 08/11/05 (X)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Job Number: 41957

Part Number: D350689041

Job Number:



Seq. #:	Machine Or Operation:	Description :
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17.0	MS24693S272	Screw
------	-------------	-------



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty Part Number Description Batch

4 MS24693-S272 Screw

M104746

SS 08/11/05 (X)

18.0	MS27039117	Screw
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Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty Part Number Description Batch

4 MS27039-1-17 Screw

M11540

SS 08/11/05 (X)

19.0	MS27039119	Screw
------	------------	-------



Comment: Qty.: 12.0000 Each(s)/Unit Total : 12.0000 Each(s)

Pick:

Qty Part Number Description Batch

12 MS27039-1-19 Screw

B10089

SS 08/11/05 (X)

20.0	D30221	Seat Pan
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number Description

1 D3022-1

Seat Pan

Batch

37874

SS 08/11/05 (X)

21.0	D3021041	Tube Assembly
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number Description

1 D3021-041

Tube Assembly

Batch

37872

SS 08/11/05 (X)

22.0	D3016041	Seat Frame Assembly
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number Description

1 D3016-041

Frame Assembly

Batch

41977

SS 08/11/05 (X)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: DUAL HIGH BACK SEAT

Job Number: 41957

Part Number: D350689041

Job Number:



Seq. #:

Machine Or Operation:

Description :

23.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

Assemble as per Dwg IIN-D350-689

CP 08/11/06

24.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

Sosulog (x0)

25.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: *PPD 3545*

91904

PC 08/11/06 (1)

26.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/11/06

Job Completion



MF 08-10-06

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DESIGN <i>CP</i>	DRAWN BY <i>CP</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>H</i>	APPROVED <i>H</i>	DRAWING NO. DSI 9349	REV. A SHEET 1 OF 1
DATE 06.08.16		TITLE RIVET CHANGE SCALE NTS	
A	06.08.16	NEW ISSUE	

DART SERVICE INSTRUCTION

TO AMEND INSTALLATION INSTRUCTIONS IIN-D350-689 Rev.A
AND INSTRUCTIONS FOR CONTINUED AIRWORTHINESS ICA-D350-689 Rev.0
REF. CANADIAN STC: SH02-33
REF. FAA STC: SR01620NY

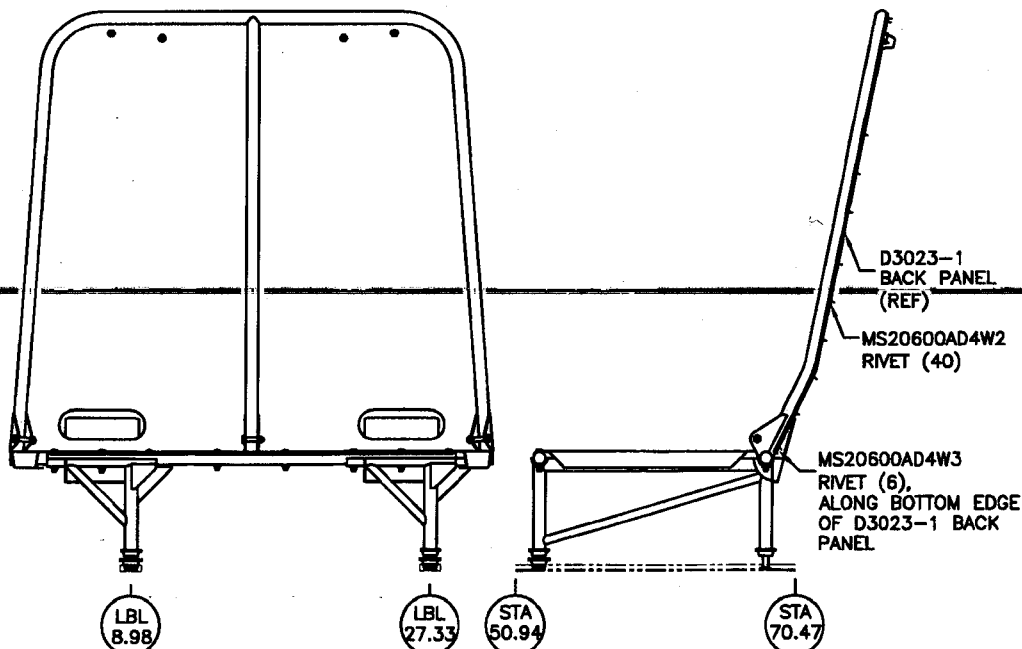
Some rivet lengths have changed, as indicated below, to ensure proper assembly of the D350-689-041 Dual High Back Seat Assembly. If installing replacement parts, it is acceptable to use longer rivets in other locations as required to ensure proper fastening. The parts list is revised as follows:

WAS:

QTY -041	Part Number	Description
X	D350-689-041	DUAL HIGH BACK SEAT ASSEMBLY
46	MS20600AD4W2	RIVET

NOW:

QTY -041	Part Number	Description
X	D350-689-041	DUAL HIGH BACK SEAT ASSEMBLY
40	MS20600AD4W2	RIVET
6	MS20600AD4W3	RIVET



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 4951

CANADA
DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-O-01

APPROVED

BY: *D. Shepherd*
D. SHEPHERD (DE # 02)

DATE: 06.08.16
CERT. NO.: SH02-33
ISSUE NO.: 1

D350-689-041 Dual High Back Seat Assembly

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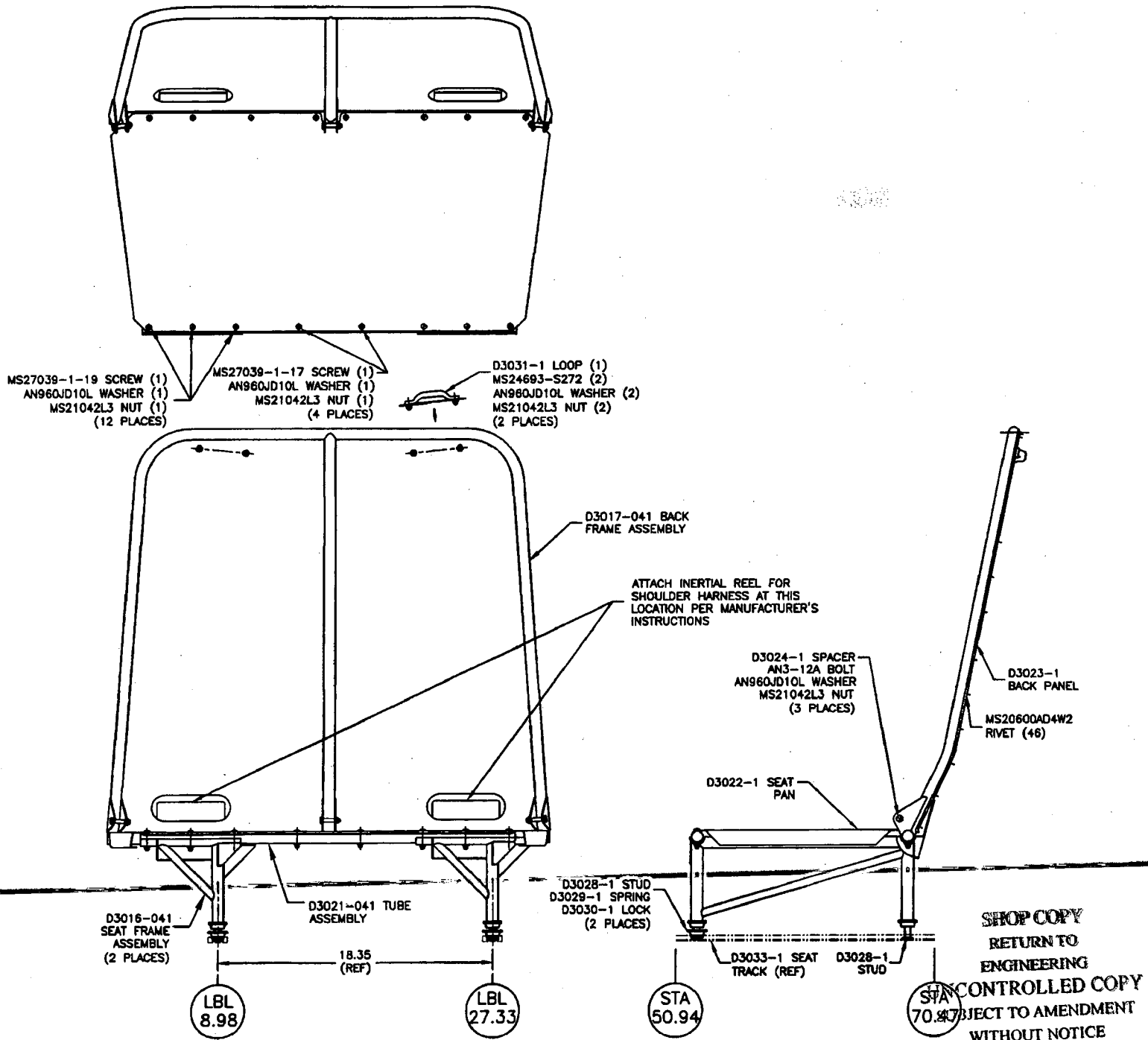


FIGURE 6: Installation of D350-689-041 Dual High Back Seat Assembly

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Revision: A
Date: 01.05.30